

Tuesday, 22/07/2008 8:49:18 AM Melanie Fauteux

Process Sheet

: ADJUSTABLE ATTACHMENT ARM ASS.Y Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 40693 Estimate Number : 13479 Part Number : PB674300159 P.O. Number : B6743001 P.14 : 22/07/2008 S.O. No. : **Drawing Number** This Issue Prsht Rev. Project Number : N/A : 11 : LARGE FAB ASSY : B1 First Issue Type **Drawing Revision** Material Previous Run : 29/07/2008 **Due Date** Written By Checked & Approved By 08-07-18 : Est Rev:A new issue DD verified by:ec **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 1.0 PB6743001113 Square Tubing Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) Square Tubing 2.0 PB6743001119 Comment: Qty.: 5.0000 Each(s) 1.0000 Each(s)/Unit Total: End Cap Clevis 3.0 PB6743001117 Comment: Qty .: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) Hook Plate 4.0 PB6743001115 Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) Tube End Plate 5.0 PB674300127 Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Doubler SP 08-08-6

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Form: rprocess





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Jstomer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

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Part Number: PB674300159

b Number:



Seq. #:

Machine Or Operation:

Description:

6.0

M6061T6T1750W065

6061T6 RDTUBE 1.750 X 0.65W -

0.1575 f(s)/Unit Total: Comment: Qty.:

6061T6 RDTUBE 1.750 X 0.65W batch:

0.7875 f(s)



7.0

LARGE FAB 1



Comment: 1- to make -105 take M6061T6 tube and fabricate to fit contour of cut

2- Weld -105 to -113 as per dwg and grind weld flush - NOT PEGD THIS BATCH ONLY TO AVOID CLACKING

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001

4- pick two -271 and weld one on each side of tubing but only one need to be trim to fit open 113 as par dwg (

PB67-43001

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

QC5



9.0

8.0

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

HAND FINISHING

HAND FINISHING RESOURCE #1



10.0

Comment: HAND FINISHING RESOURCE #1



Chemical Conversion Coat as per QSI 005 4.1

11.0

POWDER COATING

1102316

Comment: POWDER COATING

1- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE: FINISH TIME:

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



08-08-08



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ob Number:



Seq. #: Machine Or Operation: Description: 13.0 PB6743001267 PB67-43001-267 Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) PB67-43001-267 batch: 340095 08-08-06 14.0 PB6743001121 Square Sleeve 5.0000 Each(s)() Comment: Qty.: 1.0000 Each(s)/Unit Total: Square Sleeve batch: 3 406/2 15.0 BSP43 RIVET Comment: Qty.: Each(s)/Unit Total: 30.0000 Each(s) RIVET batch: 16.0 MS17984C413 PIN, QUICK RELEASE Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) PIN, QUICK RELEASE 17.0 30345T21 LANYARD Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) LANYARD batch: 18.0 MS27039122 SCREW Comment: Qty.: Total: 10.0000 Each(s) SCREW batch: 19.0 MS21042L3 Nut Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Nut 108814 08.08.26

batch:



Process Sheet

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Description:

Job Number:



Seq. #:

Machine Or Operation:

20.0

NAS1149F0332P

WASHER



Comment: Qty.:

Each(s)/Unit

Total: 20.0000 Each(s)

WASHER batch:

21.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- take -267 and transfer drill holes in -113 as per dwg PB67-43001
- 2- deburr and rivet -267 to -113 as per dwg
- 3- assemble rest of parts as per dwg PB67-43001

22.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

23.0

PACKAGING 1

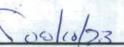
PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: (



24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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